X			The second secon				- 1				
	er ID 54849 009 7:31:00 AM						·				Page 1
Item ID: Revision ID:	D3685-041		A	Accept				iiiii s	Setup Sta		
Item Name: Start Date: Required Date: Reference:		SEMBLY t Qty: 1.00 'd Qty: 1.00			Cust Item l Customer:	D:			Sto	P	
Approvals:	Process Plan:QC:		Date: <u>09-12-30</u> Date:	Tooling: SPC (Y/N):		ate:		I	Run Sta St		18418 184 1854 18418 184 186 186
Sequence ID/ Work Center I	-	ation ription		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision I	Nbr	•								
D3685	Rev C										
	Pick F	Kit .		0.00		· /	/	(12/ 20/20		,
Packaging Packaging		Мето		0.00	Sis	10/0	194		-		22
110 !	Small	Eab		0.00				,	- 4	-	
Small Fab	Sinan	Memo		0.00					0		
Small Fab		1-Use anti- on thread a	seize compound Tectly 502c nd assemble as per dwg D368 flex -241/-291 between matin	Class 1,Mil-PRF-161 5 □2-Assemble D368	34-047 & D3687-3	\		, 1			

Quality Control .

120

Memo

QC5- Inspect part completeness to step on W/O

Duit Ac	ospucc	LIU								
W/O:		- Pro-Sudder-	V	VORK ORDER CHAN	GES					•
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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i							-			
Part No	:	PAR #:	Fault Ca	tegory:	NCF	l: Yes I	lo DQ	A :	_ Date: _	
	Re	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCR))			
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
	-									
								•		
								,		
		,								

Work Order ID 54849

December 30, 2009 7:31:00 AM

Required Date: 1/6/2010



Page 2

Item ID:

D3685-041

Accept

Setup Start

Stop

Start



Revision ID:

Item Name:

BIPOD MOUNT ASSEMBLY

Start Date:

12/31/2009

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

QC:

Process Plan:

Operation

Description

Date: _____

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Draw

Stop

Run



Qty

Sequence ID/ Work Center ID

130

Packaging Packaging

Memo

0.00

0.00

Rev. Code

Plan

Accept Qty

Reject Reject

Insp. Number Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

Memo

0.00

M. 10.01.05 MF 10-01-05

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Approval-DATE STEP PROCEDURE CHANGE Bv Qtv Date Chief Eng / Prod Mgr QC Inspector Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ WORK OPPED HON CONFORMANCE (NOD)

		Description of NC		Corrective Action Section E	3	Varification	Ammuousi	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
		#1						
4								
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1								

December 30, 2009 7:31:00 AM

Work Order ID: 54849

Parent Item:

D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Comments:



Start Date: 12/31/2009

Required Date: 1/6/2010

Start Oty: 1.00

Required Oty 1 00

Comments:					•			2	Start Qty: 1.00		Required Qty: 1.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Status Issued
AN3C12A 		Purchased	No			110	Each	356.0000	4,0000 		
				<u>Warehou</u>	<u>ise</u>	Loc	<u>Qty</u>	Loc Code	ļ		
				<u>Loca</u>			— <u> </u>		i		
				Main Wa	rehouse				1		
				ST			356		_		SB 10/01/04
22694 047			> 1		112314		356		_	4	
)3684-047 18 18 18	a ni bib i 1884 1881	Manufactured	No			110	Each	1.0000	1.0000 H ee hii		
FWD LEG ASS'Y	9111 B1011 1681 1601										
				Warehou		<u>Loc</u>	<u>Oty</u>	Loc Code			
				Loca							,
				Main Wa ST	rehouse B 548 58		1			,	\$ 10/01/04
				31	45600		1		_	·	- 56 10/01/07
D3684-049		Manufactured	No		45000	110	Each	5.0000	1.0000		
AFT LEG ASS'Y	B) 1										
				Warehou	<u>ise</u>	Loc	<u>Qty</u>	Loc Code			
			-	Loca	tion						
				Main Wa	rehouse						83 voloilo4
				ST			5		-		- molecto4
					45601		1		_	7	- 83 (01)
					48169		4				_

	Johado									
W/O:		10-20-12-12-12-12-12-12-12-12-12-12-12-12-12-	WO	RK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· · · · · · · · · · · · · · · · · · ·	,			·						
Part No		PAR #:								
	Re	solution:	Disposition	:	QA	: N/C Cld	osed:		Date: _	· · · · · · · · · · · · · · · · · · ·
NCR:	, ,	,	WORK ORDE	R NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip Chief Eng	Section B tion	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
		·								

Picklist Print

Page 2

December 30, 2009 7:31:00 AM

Work Order ID: 54849

Parent Item:

D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Comments:



51096

Start Date: 12/31/2009

Required Date: 1/6/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3687-3 MOUNT		Manufactured	No			110	Each	15.0000	1.0000 1.0000 1.0000			
				<u>Wareho</u> <u>Loca</u>		Loc	<u>Oty</u>	Loc Code				
				Main Wa	arehouse				1			
				ST			9		_		<i>*</i>)
					45912 46761		2 7				Sis 109 01	104
				Main Wa	arehouse				1			
				ST1	18		6					

SPACER

D3692-1

Manufactured

No

110

6

Each

654.0000 8.0000

Warehouse Location	Loc Oty	Loc Code
Main Warehouse		
ST	59	
44827	8	
45672	14	·
50325	37	
Main Warehouse		SB 10/01/04
ST127	595	
50736	187	
51467	408	

	. Johnson							
W/O:		1	WO	RK ORDER CHANG	ES			, f.
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _	
	Res	olution:	Disposition	i:	_ QA: N/C Cld	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)		, <u></u>
DATE	STEP	Description of NC			tion B	Verification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
						·		

Picklist Print

December 30, 2009 7:31:00 AM

Work Order ID: 54849

Parent Item:

D3685-041

Parent Item Name:

BIPOD MOUNT ASSEMBLY

Comments:



Last

Start Date: 12/31/2009

Required Date: 1/6/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Repla
Item Name	Item I

m

acement Mfg/ Purch

Bin Primary Item Location Location

Route Seq ID Unit of Measure

Qty on Hand

Remaining Qty Oty To Pick Issued Date Issued

Status

Page 3

MS21043-3

Purchased

No

110

Each

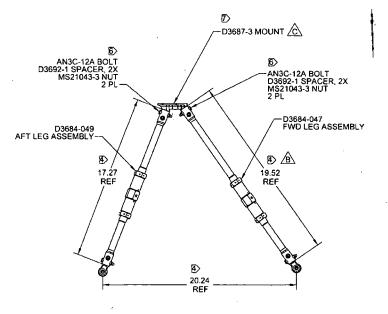
4,548.000 4.0000

Nut

<u>Warehouse</u>	Loc Qty	Loc Code	
Location			
OFFSHORE			
FG	80		
103691	80		
Main Warehouse			
ST	4468		
111819	70		Sh (0 (°
112243	29		·
112314	4369	•	

			•							
W/O:			V	ORK ORDER CHANG	SES					*
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			· · · · · · · · · · · · · · · · · · ·							
4										
							 , -			
Part No	:	PAR #:	Fault Ca	tegory:	_ NCF	R: Yes N	lo DQA	\ :	_ Date: _	
	Re	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR)	١			
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
	,									
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QTY -041 ITEM PART NUMBER DESCRIPTION D3685-041 Х BIPOD MOUNT ASSEMBLY 2 D3687-3 MOUNT D3684-047 3 FWD LEG ASSEMBLY D3684-049 AFT LEG ASSEMBLY D3692-1 SPACER AN3C-12A BOLT MS21043-3





С

D3685-041 BIPOD MOUNT ASSEMBLY

Α

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NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED
3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY PIN D3685-041 USING FINE POINT PERMANENT INK MARKER
4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
5) WEIGHT: 6.6 ibs
6) TORQUE FASTENERS TO 20-25 in-lbs
7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR
MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	<u> </u>	RF	DART AFROSPA	CEL	TD
REV.		DE	SCRIPTION	BY	DATE
A	NEW ISS	UE		RF	08.05.22
В	19.52 WA	S 19.95 (ZN 84- ANDARDS	I); REFORMATTED TO CURRENT	RF	08.11.24
С			S SEALANT (ZN A8-1, C4-1)	RF	08.12.15

DESIGN	RF	DART AEROSPACE LTD					
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA					
CHECKED	Ro	DRAWING NO. REV. (
MFG. APPR.	Tolk.	D3685 SHEET 1 OF					
APPROVED	MM.	TITLE SCALI					
DE APPR.		BIPOD MOUNT ASSEMBLY NTS					
DATE 08.	12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS SPENTE AND COMPONENT HOUR SUPPLIED ON THE CHRISTS CONTINUED HAVE OF SPENTE AND THE CHRISTON THAT IT IS NOT TO SELECTED FOR ANY PLATOGE OF COPIED ON COMMENTED TO AN OTHER PLATONYCHICUT.					

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Dart Ae	rospace	e Ltd							
W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory: I	NCR: Yes	No DQ	A :	Date: _	
Resolution:		Disposition: QA			A: N/C Closed: Date:				
NCR:			WORK OR	DER NON-CONFORMAN	CE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation	Approvai	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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